

# Work Order ID 83282

April-16-12 2:28:25 PM

\*83282\*

**U/R**

Page 1

Item ID: D350-748-141TRN

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID: U/R

Item Name: Crosstube Turning Detail

Stop \*NS2\*

Start Date: 16/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/16 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D350-748-141

F U/R 12.04.16 OK

100

0.00

\*100\*

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs on both ends as per Folio FA648

2-Turn first side as per Folio FA648

3- File transition lines smooth.

FOLIO REV:

DWG REV:

1  $\phi$

mm.l

12/04/26

110

QC1- Inspect dimensions to dimension sheet

0.00

\*110\*

QC

Memo

0.00

Quality Control

1  $\phi$

mm.l

12/04/26

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 83282

April-16-12 2:28:25 PM

**\*83282\***

Page 2

Item ID: D350-748-141TRN

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID: U/R

Item Name: Crosstube Turning Detail

Stop **\*NS2\***

Start Date: 16/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                                                                                                                                         | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120                            |                                                                                                                                                                  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*120*</b>                   | MORI SEIKI CNC LATHE LARGE                                                                                                                                       |                      |         |        |              |               |               |                  |                |
| Mori Seiki                     | Memo                                                                                                                                                             | 0.00                 |         |        |              |               |               |                  |                |
| Mori Seiki CNC Lathe Large     | 1-Turn second side as per Folio FA648<br>2- File transition lines smooth.<br>3-Scribe Part & Batch as per Dwg D350-748-141<br>FOLIO REV: _____<br>DWG REV: _____ |                      |         |        |              |               |               |                  |                |
| 130                            |                                                                                                                                                                  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*130*</b>                   | QC1- Inspect dimensions to dimension sheet                                                                                                                       |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                                                                                                                             | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                                                                                                                                  |                      |         |        |              |               |               |                  |                |
| 140                            |                                                                                                                                                                  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*140*</b>                   | QC8- Inspect parts - second check                                                                                                                                |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                                                                                                                             | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                                                                                                                                  |                      |         |        |              |               |               |                  |                |

*mm*  
12/04/20

*mm*  
12/04/20

*DP* 12-4-30

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 83282

**\*83282\***

Page 4

April-16-12 2:28:25 PM

Item ID: D350-748-141TRN  
Revision ID: U/R  
Item Name: Crosstube Turning Detail

Accept

**\*N900040100\***

Setup Start **\*NS1\***  
Stop **\*NS2\***

Start Date: 16/04/2012 Start Qty: 1.00 **\*1\***  
Required Date: 30/04/2012 Req'd Qty: 1.00 **\*1\***


Cust Item ID:  
Customer:

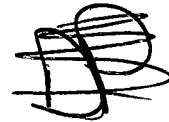
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                | Operation<br>Description                                                      | Set Up/<br>Run Hours | Tool ID | Tool #    | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-----------------------------------------------|-------------------------------------------------------------------------------|----------------------|---------|-----------|--------------|---------------|---------------|------------------|----------------|
| 180<br><b>*180*</b><br>QC<br>Quality Control  | QC6- Inspect dimensions to drawing<br><br>Memo                                | 0.00<br>0.00         |         |           |              |               |               |                  |                |
|                                               |                                                                               |                      |         | S, 2/9/13 |              |               |               |                  |                |
| 190<br><b>*190*</b><br>Packaging<br>Packaging | Packaging<br><br>Memo<br>Identify and stock in kanban rack<br>Location: _____ | 0.00<br>0.00         |         |           |              |               |               |                  |                |
|                                               |                                                                               |                      |         | B 87336   |              |               |               |                  |                |
| 200<br><b>*200*</b><br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo                       | 0.00<br>0.00         |         |           |              |               |               |                  |                |
|                                               |                                                                               |                      |         |           |              |               |               |                  |                |

 12-9-13

 13/5/22

u 1209.14

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

April-16-12 2:28:29 PM

Page 1

Work Order ID: 83282

\*83282\*

Parent Item: D350-748-141TRN

\*D350-748-141TRN\*

Parent Item Name: Crosstube Turning Detail

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:A New Issue 08-03-06 DD verified by:ec  
IPP Rev B Removed polish 08.04.02 EC verified by : DD  
IPP Rev C Remove LPS-3 08.06.23 EC verified by DD IPP Rev C  
11.02.24 as per dwg rev.F DD verf: JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6015-125                       |                        | Manufactured  | No          |                     |                  | 110             | Each               | 44.0000        | 1           | 1            |               |                |        |

\*D6015-125\*

Crosstube Material

\*\*

## Location

## Loc Qty

## Loc Code

HALL

44

61380

4

72511

40

12-4-24

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|                                                             |                                  |
|-------------------------------------------------------------|----------------------------------|
| <b>DART AEROSPACE LTD</b>                                   | <b>Work Order:</b> 83282         |
| <b>Description:</b> Crosstube Assembly (AS350/355 High Fwd) | <b>Part Number:</b> D350-748-141 |
| <b>Inspection Dwg:</b> D350-748-141 <b>Rev:</b> F           | <b>Page 1 of 1</b>               |

### FIRST ARTICLE INSPECTION CHECKLIST

| Inspection Sheet<br>Drawing Dimension | Tolerance | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|---------------------------------------|-----------|---------------------|--------|--------|-------------------------|----------|
| SIDE A                                | 2.240     | +0.005/-0.000       | 2.244  | /      | vern                    | CWK-08   |
|                                       | 2.180     | +0.005/-0.000       | 2.184  | /      |                         |          |
|                                       | 2.180     | +0.005/-0.000       | 2.185  | /      |                         |          |
|                                       | 2.237     | +0.005/-0.000       | 2.241  | /      |                         |          |
|                                       | 2.272     | +0.005/-0.000       | 2.275  | /      |                         |          |
|                                       | 2.306     | +0.005/-0.000       | 2.311  | /      |                         |          |
|                                       | 2.339     | +0.007/-0.000       | 2.345  | /      |                         |          |
|                                       | 2.339     | +0.007/-0.000       | 2.348  | /      |                         |          |
|                                       | 0.062     | +/-0.010            | .062   | /      | vern                    | CWK-08   |
|                                       | 4.26      | +/-0.030            | 4.26   | /      | "                       |          |
|                                       | R0.063    | +/-0.010            | .063   | /      | RG                      |          |
|                                       | R0.50     | +/-0.030            | .500   | /      | "                       |          |
|                                       |           |                     |        |        |                         |          |
|                                       |           |                     |        |        |                         |          |
| SIDE B                                | 2.240     | +0.005/-0.000       | 2.244  | /      | vern                    | CWK-08   |
|                                       | 2.180     | +0.005/-0.000       | 2.185  | /      |                         |          |
|                                       | 2.180     | +0.005/-0.000       | 2.185  | /      |                         |          |
|                                       | 2.237     | +0.005/-0.000       | 2.241  | /      |                         |          |
|                                       | 2.272     | +0.005/-0.000       | 2.276  | /      |                         |          |
|                                       | 2.306     | +0.005/-0.000       | 2.311  | /      |                         |          |
|                                       | 2.339     | +0.007/-0.000       | 2.345  | /      |                         |          |
|                                       | 2.339     | +0.007/-0.000       | 2.348  | /      |                         |          |
|                                       | 0.062     | +/-0.010            | .062   | /      | vern                    | CWK-08   |
|                                       | 4.26      | +/-0.030            | 4.26   | /      | "                       |          |
|                                       | R0.063    | +/-0.010            | .063   | /      | RG                      |          |
|                                       | R0.50     | +/-0.030            | .500   | /      | "                       |          |
|                                       |           |                     |        |        |                         |          |
|                                       |           |                     |        |        |                         |          |
|                                       | 110.27    | +/-0.060            | 110.27 | /      | tape                    | mm. 1-02 |

|                              |
|------------------------------|
| <b>Measured by:</b> KC/mm. 1 |
| <b>Date:</b> 12-4-24         |

|                       |
|-----------------------|
| <b>Audited by:</b> DD |
| <b>Date:</b> 12-4-30  |

|                              |
|------------------------------|
| <b>Preliminary Approval:</b> |
| <b>Date:</b>                 |

| Rev | Date     | Change                                 | Revised by | Approved |
|-----|----------|----------------------------------------|------------|----------|
| A   | 06.11.09 | New Issue (P/O D350-748-101)           | KJ/JLM     |          |
| B   | 07.10.24 | Dwg Rev updated                        | KJ/EC/DD   |          |
| C   | 11.01.20 | Dwg Rev updated                        | KJ         |          |
| D   | 11.07.26 | Tolerance revised for 2.339 dimensions | KJ         |          |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

| Item | Qty<br>-141 | Part Number   | Description                            |
|------|-------------|---------------|----------------------------------------|
| 1    | X           | D350-748-141  | CROSSTUBE ASSEMBLY (AS 350/355 HI FWD) |
| 2    | 1           | D6015-125     | CROSSTUBE (OR D6017-115)               |
| 3    | 2           | D3502-1       | SUPPORT                                |
| 4    | 2           | D2856-400-710 | ABRASION STRIP                         |
| 5    | 1           | AELS-1032-225 | INSERT                                 |
| 6    | 1           | NAS1149D0363J | WASHER (OR AN960JD10)                  |
| 7    | 2           | MS21920-20    | CLAMP (PER DART SPEC. M-MS21920-20)    |
| 8    | 1           | MS27039-1-10  | SCREW                                  |

# GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115  
FINISHED LENGTH = 110.270±0.06
- FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF  
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- WEIGHT: 30.45 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.  
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO  
VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE,  
CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,  
NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.  
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE  
MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO  
CRACKING/CHIPPING/GROOVES.
- TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT  
NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN  
CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 03282 MCT  
12/04/16

UNDER REVIEW  
11.07.12

RELEASED  
2011-01-18

|            |                                                                                                                                           |                                                                                                                                                                                                                                                                                |              |
|------------|-------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| F          | ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD<br>TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION<br>(C8-1), STOCK DIM NOW MACHINED (D1-4) | CP                                                                                                                                                                                                                                                                             | 10.11.23     |
| E          | REVISE GENERAL NOTES; UPDATE TO CURRENT ADD<br>STANDARDS; RELOCATED FLAG #6 PER PAR 08-046<br>(ZN A8-3); TOLERANCES (ZN C6-3, D1-3)       | RF                                                                                                                                                                                                                                                                             | 09.09.30     |
| D          | MAG. PARTICLE AND CAD PLATE AS MFD.                                                                                                       | CP                                                                                                                                                                                                                                                                             | 06.10.31     |
| C          | ADD CAD PLATING                                                                                                                           | CP                                                                                                                                                                                                                                                                             | 06.08.14     |
| B          | ADD D6017-115 & PRIME AND PAINT                                                                                                           | CP                                                                                                                                                                                                                                                                             | 06.06.30     |
| A          | NEW ISSUE                                                                                                                                 | CP                                                                                                                                                                                                                                                                             | 06.03.31     |
| REV.       | DESCRIPTION                                                                                                                               | BY                                                                                                                                                                                                                                                                             | DATE         |
| DESIGN     | 92                                                                                                                                        | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                              |              |
| DRAWN      | 92                                                                                                                                        |                                                                                                                                                                                                                                                                                |              |
| CHECKED    | 92                                                                                                                                        | DRAWING NO.                                                                                                                                                                                                                                                                    | REV. F       |
| MFG. APPR. | 92                                                                                                                                        | D350-748-141                                                                                                                                                                                                                                                                   | SHEET 1 OF 4 |
| APPROVED   | 92                                                                                                                                        | TITLE                                                                                                                                                                                                                                                                          | SCALE        |
| DE APPR.   | 92                                                                                                                                        | CROSSTUBE (AS 350/355 HI FWD)                                                                                                                                                                                                                                                  | NTS          |
| DATE       | 10.11.23                                                                                                                                  | COPYRIGHT © 2006 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

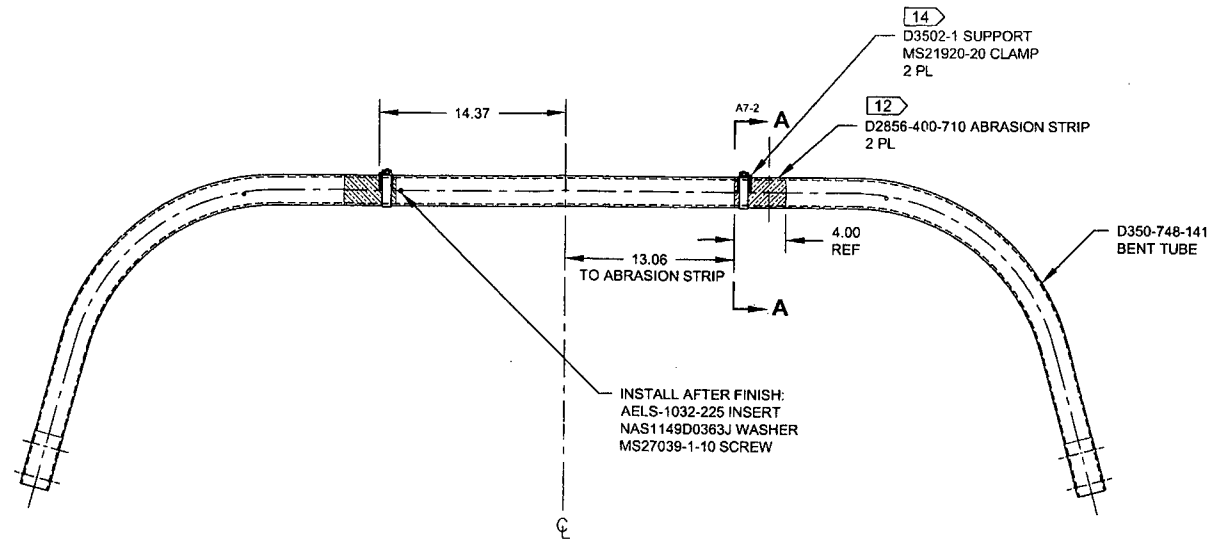
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

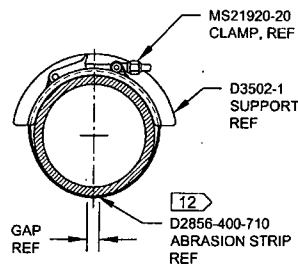
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

83282



**D350-748-141  
ASSEMBLY DETAIL**



**SECTION A-A** D4-2  
SCALE 4X

UNDER REVIEW

RELEASED  
2011-01-18

|                                                                                                                                                                                                                                 |          |                                        |              |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                          | 92       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                           | 92       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                         | 92       | DRAWING NO.                            | REV. F       |
| MFG. APPR.                                                                                                                                                                                                                      | 12       | D350-748-141                           | SHEET 2 OF 4 |
| APPROVED                                                                                                                                                                                                                        | 12       | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                        | 12       | CROSSTUBE (AS 350/355 HI FWD)          | NTS          |
| DATE                                                                                                                                                                                                                            | 10.11.23 | COPYRIGHT © 2006 BY DART AEROSPACE LTD |              |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

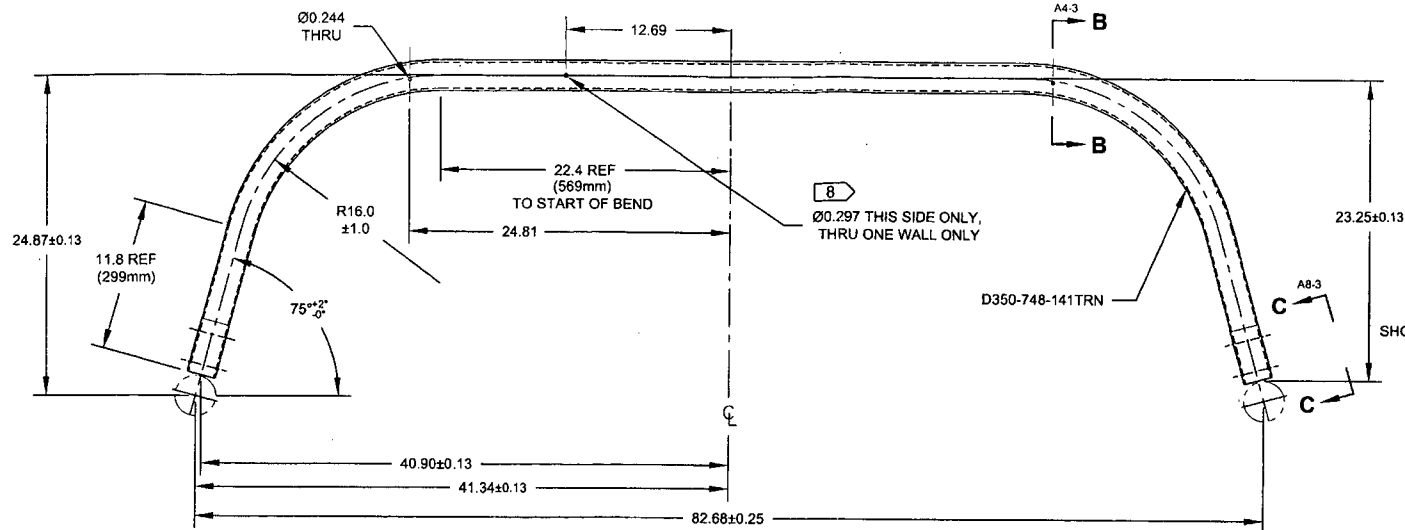
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

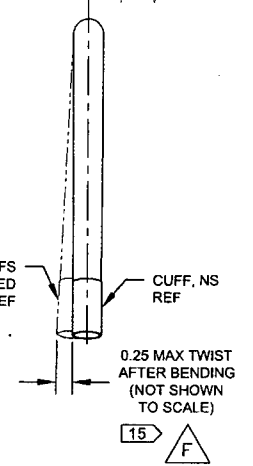
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

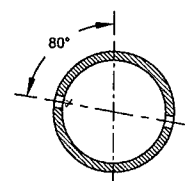
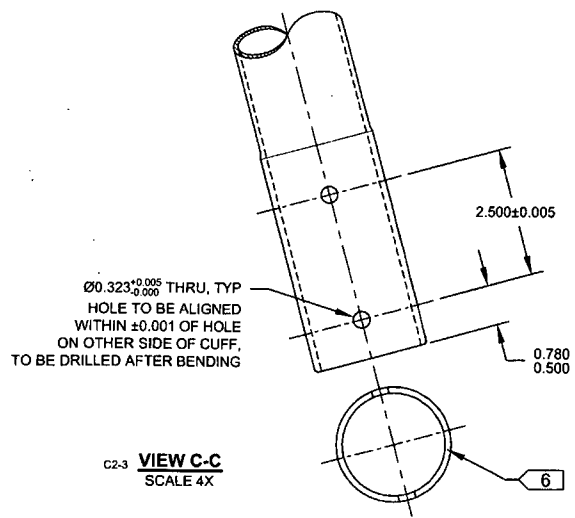




85282



**D350-748-141**  
**BENDING AND DRILLING DETAIL** 10



UNDER REVIEW  
11.07.12

RELEASED  
2011-01-18

|            |          |                                                                                                                                                                                                                                                                         |              |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | qp       | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                               |              |
| DRAWN      | qp       | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                             |              |
| CHECKED    | h        | DRAWING NO.                                                                                                                                                                                                                                                             | REV. F       |
| MFG. APPR. | h        | D350-748-141                                                                                                                                                                                                                                                            | SHEET 3 OF 4 |
| APPROVED   | h        | TITLE                                                                                                                                                                                                                                                                   | SCALE        |
| DE APPR.   | h        | CROSSTUBE (AS 350/355 HI FWD)                                                                                                                                                                                                                                           | NTS          |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

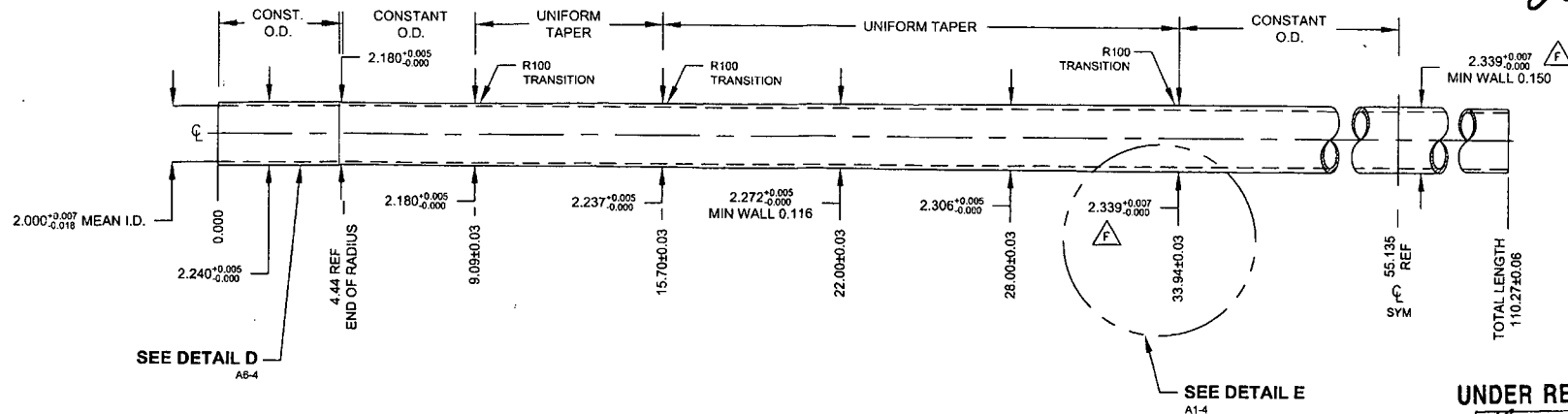
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

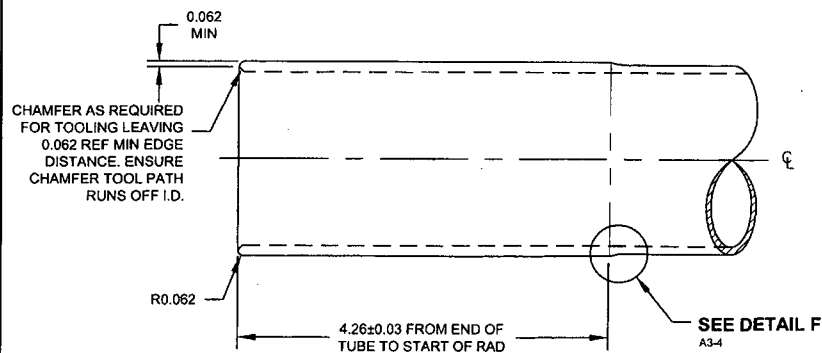
**NOTE:** Date & initial all entries

93282

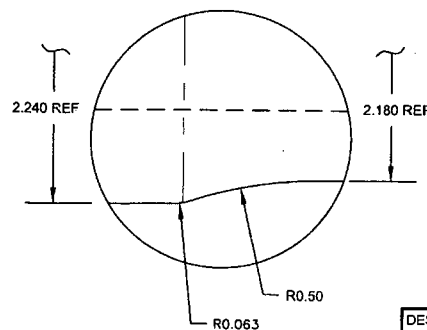


**D350-748-141TRN  
TURNING DETAIL**

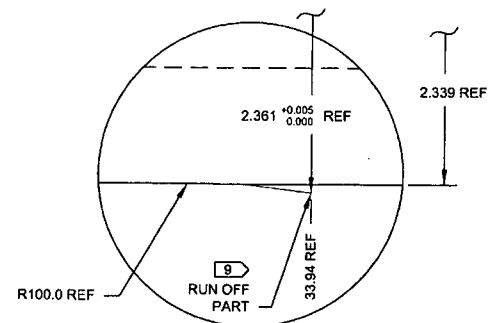
UNDER REVIEW  
11.07.12



**DETAIL D:  
CROSSTUBE CUFF** C7-4  
SCALE 3X



**DETAIL F:  
CUFF TRANSITION** A5-4  
NOT TO SCALE



**DETAIL E:  
TAPER RUN-OFF** C3-4  
NOT TO SCALE

RELEASED  
2011-01-18

|                                                                                                                                                                                                                                 |          |                                        |              |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                          | JP       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                           | JP       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                         | JS       | DRAWING NO.                            | REV. F       |
| MFG. APPR.                                                                                                                                                                                                                      | JS       | D350-748-141                           | SHEET 4 OF 4 |
| APPROVED                                                                                                                                                                                                                        | JS       | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                        | JS       | CROSSTUBE (AS 350/355 HI FWD)          | NTS          |
| DATE                                                                                                                                                                                                                            | 10.11.23 | COPYRIGHT © 2006 BY DART AEROSPACE LTD |              |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



1000 E. Mermaid Ln., Wyndmoor (Phila.) PA 19038-8093  
Tel: (215) 233-2600 Fax (215) 233-5653

## Certification

### SOLD TO

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7

June 5, 2012

---

|                              |                                                          |
|------------------------------|----------------------------------------------------------|
| <b>Metlab Shop Order No:</b> | 72197                                                    |
| <b>Purchase Order:</b>       | 16899                                                    |
| <b>Description:</b>          | Crosstube                                                |
| <b>Part No.:</b>             | D350-748-141TRN, D350-748-241TRN                         |
| <b>Quantity:</b>             | 7 and 4 Pieces, Respectively                             |
| <b>Weight:</b>               | 500 Pounds                                               |
| <b>Material:</b>             | 4130 Alloy Steel                                         |
| <b>Specifications:</b>       | Heat Treat to Minimum 180 KSI (MIL-T-6736OR AMS 2759-IC) |
| <b>Note:</b>                 | Need HRC 40 - 45                                         |

---

This is to certify that the above parts were processed as indicated above and conform to the specification requirements.

### Results:

HRC 45 (218 KSI Tensile Strength, Converted)

METLAB

Quality Representative Mark Podob

MERCURY CONTAMINATION: During the heat treating process, testing and inspections, the product did not come in direct contact with mercury or any of its compounds nor with any mercury containing device.



Heat Treating and Metallurgical Consulting



REMEASURED AFTER HEAT-TREAT & SAND BLAST.

|                                                             |  |                                  |
|-------------------------------------------------------------|--|----------------------------------|
| <b>DART AEROSPACE LTD</b>                                   |  | <b>Work Order:</b> 83282         |
| <b>Description:</b> Crosstube Assembly (AS350/355 High Fwd) |  | <b>Part Number:</b> D350-748-141 |
| <b>Inspection Dwg:</b> D350-748-141 Rev: F                  |  | <b>Page 1 of 1</b>               |

### FIRST ARTICLE INSPECTION CHECKLIST

| Inspection Sheet | Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| SIDE A           | 2.240             | +0.005/-0.000 | 2.240            | /      |        | VERN                 | VERN     |
|                  | 2.180             | +0.005/-0.000 | 2.180            | /      |        |                      | CNC-08   |
|                  | 2.180             | +0.005/-0.000 | 2.180            | /      |        |                      |          |
|                  | 2.237             | +0.005/-0.000 | 2.235            | /      | ✓      |                      |          |
|                  | 2.272             | +0.005/-0.000 | 2.275            | /      |        |                      |          |
|                  | 2.306             | +0.005/-0.000 | 2.311            | /      |        |                      |          |
|                  | 2.339             | +0.007/-0.000 | 2.336            | /      | ✓      |                      |          |
|                  | 2.339             | +0.007/-0.000 | 2.344            | /      |        |                      |          |
|                  | 0.062             | +/-0.010      | .063             | /      |        |                      |          |
|                  | 4.26              | +/-0.030      | 4.26             | /      |        |                      |          |
|                  | R0.063            | +/-0.010      | .063             | /      |        | RG                   |          |
|                  | R0.50             | +/-0.030      | .50              | /      |        | RG                   |          |
|                  |                   |               |                  |        |        |                      |          |
|                  |                   |               |                  |        |        |                      |          |
| SIDE B           | 2.240             | +0.005/-0.000 | 2.235            | /      |        | VERN                 | CNC-08   |
|                  | 2.180             | +0.005/-0.000 | 2.175            | /      | ✓      |                      |          |
|                  | 2.180             | +0.005/-0.000 | 2.181            | /      |        |                      |          |
|                  | 2.237             | +0.005/-0.000 | 2.238            | /      |        |                      |          |
|                  | 2.272             | +0.005/-0.000 | 2.276            | /      |        |                      |          |
|                  | 2.306             | +0.005/-0.000 | 2.306            | /      |        |                      |          |
|                  | 2.339             | +0.007/-0.000 | 2.330            | /      | ✓      |                      |          |
|                  | 2.339             | +0.007/-0.000 | 2.344            | /      |        |                      |          |
|                  | 0.062             | +/-0.010      | .063             | /      |        |                      |          |
|                  | 4.26              | +/-0.030      | 4.26             | /      |        |                      |          |
|                  | R0.063            | +/-0.010      | .063             | /      |        | RG                   |          |
|                  | R0.50             | +/-0.030      | .50              | /      |        | RG                   |          |
|                  |                   |               |                  |        |        |                      |          |
|                  |                   |               |                  |        |        |                      |          |
|                  | 110.27            | +/-0.060      | 110.27           | /      |        | TAPE                 | MM-02    |

2.337  
@ SUPPLY

2.340  
@ SUPPLY

|                        |                    |                              |
|------------------------|--------------------|------------------------------|
| <b>Measured by:</b> KC | <b>Audited by:</b> | <b>Preliminary Approval:</b> |
| <b>Date:</b> 12-6-06   | <b>Date:</b>       | <b>Date:</b>                 |

| Rev | Date     | Change                                 | Revised by | Approved |
|-----|----------|----------------------------------------|------------|----------|
| A   | 06.11.09 | New Issue (P/O D350-748-101)           | KJ/JLM     |          |
| B   | 07.10.24 | Dwg Rev updated                        | KJ/EC/DD   |          |
| C   | 11.01.20 | Dwg Rev updated                        | KJ         |          |
| D   | 11.07.26 | Tolerance revised for 2.339 dimensions | KJ         |          |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

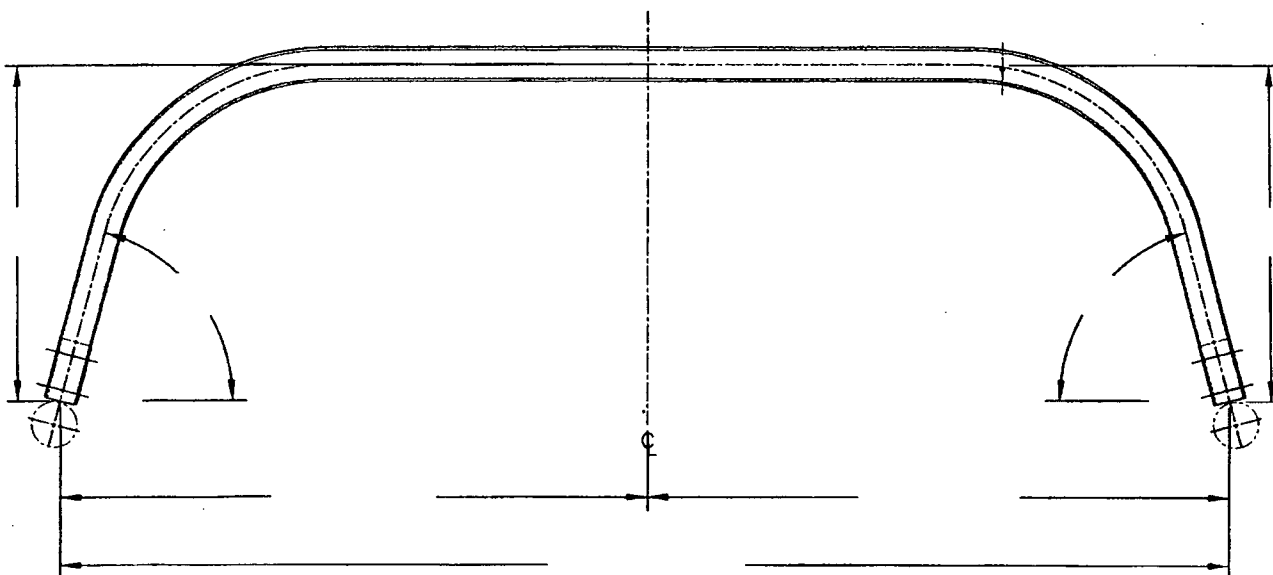
**NOTE:** Date & initial all entries



|                                                    |               |                                  |
|----------------------------------------------------|---------------|----------------------------------|
| <b>DART AEROSPACE LTD</b>                          |               | <b>Work Order:</b> 03282         |
| <b>Description:</b> Crosstube High Fwd (AS350/355) |               | <b>Part Number:</b> D350-748-101 |
| <b>Inspection Dwg:</b> D350-748-141                | <b>Rev:</b> F | <b>Page 1 of 1</b>               |

After Stress Relief

| Required Dimension | Min   | Max   |
|--------------------|-------|-------|
| Height             | 23.12 | 23.38 |
| 1/2 Span           | 40.77 | 41.03 |
| Angle              | 75    | 77    |
| Total Span         | 81.55 | 82.05 |
| Bending Passes     | 7     | --    |
| Crushing           | --    | 6%    |
| Twist              | --    | 0.25  |



|                       | Side A | Side B |
|-----------------------|--------|--------|
| <b>Bending Passes</b> |        |        |
| <b>Crushing</b>       |        |        |
| <b>Comments</b>       |        |        |
|                       |        |        |
|                       |        |        |
|                       |        |        |
|                       |        |        |

|                        |  |
|------------------------|--|
| <b>QC15 Inspection</b> |  |
| <b>Date</b>            |  |

| Rev | Date     | Change                                     | Revised by | Approved |
|-----|----------|--------------------------------------------|------------|----------|
| A   | 07.02.06 | New Issue                                  | KJ/JM      |          |
| B   | 10.08.23 | Dwg Rev updated                            | KJ         |          |
| C   | 11.11.07 | Dwg Rev updated                            | KJ         |          |
| D   | 12.04.16 | Added bending, crushing & twist dimensions | KJ         |          |